

# Work Order ID 55316

January 13, 2010 10:20:44 AM

Page 1

Item ID: D2229

Accept

Setup Start

Revision ID:

Stop

Item Name: Doubler

Start Date: 1/13/10

Start Qty: 20.00

Cust Item ID:

Required Date: 1/20/10

Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-1-13

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2229

Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2229 11 Dwg Rev: B 12-  
Deburr if necessary

2004.063

Deburr = 7 min 10/01/26

HB 10-1-21

(37x) (37)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 10-1-21

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2010/01/26

located  
(x36)

Pro >

W/O: 55316		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/6/26	#120	Took Qty x1 For inspection template	S	10/6/26	x1		S 10/6/26

Part No: D2029 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 55316**

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Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Debur. No sharp edges

0.00

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

⇒ 11 10-01-27

(X37) φ

37 10-01-28.

(37) φ

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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Start Qty: 20.00

Cust Item ID:

Required Date: 1/20/10

Req'd Qty: 20.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: 9

0.00



Packaging

Memo

0.00

Packaging

10-1-29

360 SF

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/02

MF

10-1-29

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

# Picklist Print

Page 1

January 13, 2010 10:20:48 AM

Work Order ID: 55316



Parent Item: D2229

Parent Item Name: Doubler

Start Date: 1/13/10

Required Date: 1/20/10

Comments: IPP: A02.06.05 New Issue NGL  
IPP Rev:B 07-08-15 Now On WaterJet JLM Verified By:EC

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	24.4396	1.0968	1.47		



2024-T3 .063 sheet



B 10-1-01

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	24.43962419	
102942	1.5	
105916	1.09	
106223	1.47	
109463	0.00947368	
110980	5.4854	
111787	12.8847505	
19059	2	

\_\_\_\_\_  
\_\_\_\_\_  
106223  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

(37)

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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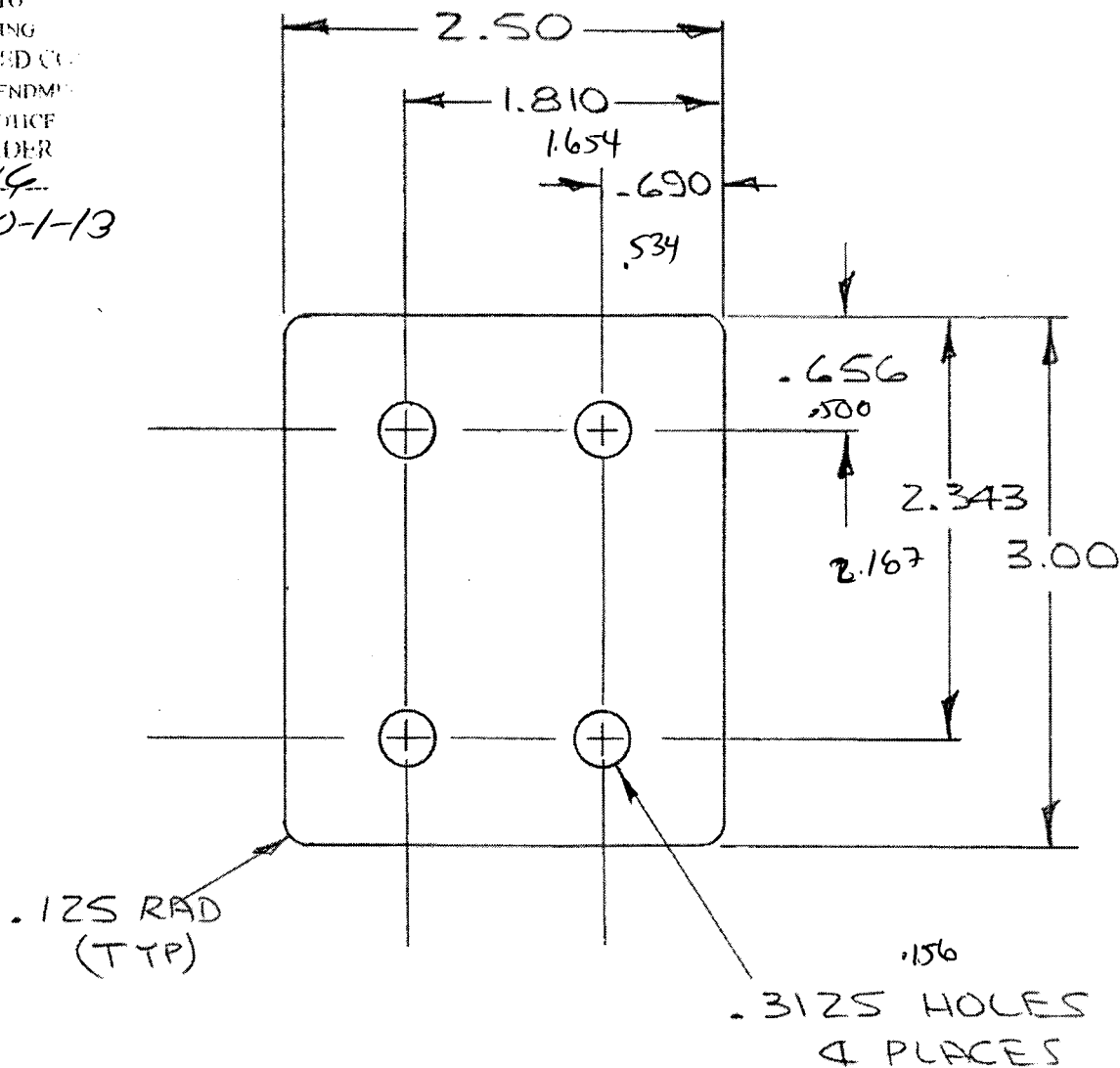
**NOTE:** Date & initial all entries

**DART**

DRAWN BRADLEY 94-3-28		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN BRADLEY 94-3-28		DRAWING NO. D2229	
		REV. B SHEET 1 OF 1	
		TITLE DOUBLER	
A	NEW ISSUE		94/3/8
B	ALODINE WAS ANODIZE		27/11/06

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35314

BS 10-1-13



MATERIAL: 2024-T3 ALUMINUM  
.063 THICK

FINISH: ALODINE PER QSI 005-4.1

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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